

Work Order ID 68210

Friday, April 08, 2011 11:49:51 AM



Page 1

Item ID: D3574-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐Dwg Rev: B ☐Prog Rev: B ☐2-
Deburr if necessaryB11-4-132

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ml 11 04 13 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

4/04/14 (2)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11 04 14 (2)

150

0.00



Identify as per dwg & Stock Location: _____

Packaging

Memo

0.00

Packaging

11/4/14 sl (2)

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Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/18
mf
11-04-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, April 08, 2011 11:50:00 AM

Page 1

Work Order ID: 68210



Parent Item: D3574-6



Parent Item Name: Cabin Floor Protector

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,844.715		67.23362			
GE PLASTICS LEXAN SHEET													

HB11-4-13

Location

Loc Qty

Loc Code

MAT018

2844.715789

112585

56

115261

768

116236

2020.71579

115261

②

W/O:		WORK ORDER CHANGES						
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DART AEROSPACE LTD	Work Order:	<i>68210</i>
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	✓		VIB 02	
7.37	+/-0.030	7.37	x		TH301	
11.00	+/-0.030	11.06	✓		T	
15.25	+/-0.030	15.24	✓		T	
25.87	+/-0.030	25.87	✓		T	
39.75	+/-0.030	39.75	✓		T	
44.75	+/-0.030	44.75	✓		T	
58.38	+/-0.030	58.38	✓		T	
63.50	+/-0.030	63.50	x		T	
65.25	+/-0.030	65.25	✓		T	
10.25	+/-0.030	10.25	✓		T	
11.87	+/-0.030	11.87	✓		T	
14.75	+/-0.030	14.75	✓		T	
26.00	+/-0.030	26.00	✓		T	
40.87	+/-0.030	40.87	✓		T	
45.00	+/-0.030	45.00	✓		T	
48.00	+/-0.030	48.00	✓		T	
55.13	+/-0.030	55.13	x		T	
61.25	+/-0.030	61.25	✓		T	
61.88	+/-0.030	61.88	✓		T	
64.63	+/-0.030	64.63	✓		T	
1.13	+/-0.030	1.13	x		T	
7.63	+/-0.030	7.63	✓		T	
11.00	+/-0.030	11.00	✓		T	
22.10	+/-0.030	22.10	✓		T	
22.50	+/-0.030	22.50	✓		T	
24.50	+/-0.030	24.50	✓		T	
35.13	+/-0.030	35.13	✓		T	
36.50	+/-0.030	36.50	✓		T	
40.00	+/-0.030	40.00	✓		T	
41.88	+/-0.030	41.88	x		T	
43.63	+/-0.030	43.63	✓		T	
6.75	+/-0.030	6.75	✓		T	
9.50	+/-0.030	9.50	✓		T	

W/O:		WORK ORDER CHANGES						
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DART AEROSPACE LTD		Work Order:	68210
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	X		T RB02	
14.50	+/-0.030	14.56	X		T	
16.75	+/-0.030	16.75	A		T	
18.94	+/-0.030	18.94	A		T	
19.00	+/-0.030	19.06	X		T	
24.13	+/-0.030	24.13	A		T	
33.88	+/-0.030	33.88	A		T	
39.50	+/-0.030	39.56	X		T	
40.25	+/-0.030	40.26	X		T	
43.50	+/-0.030	43.56	X		T	
46.60	+/-0.030	46.60	A		T	
0.125	+/-0.010	0.130	X		V RB01	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-4-13	Date: 11-04-13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ [Signature]	[Signature]

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SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

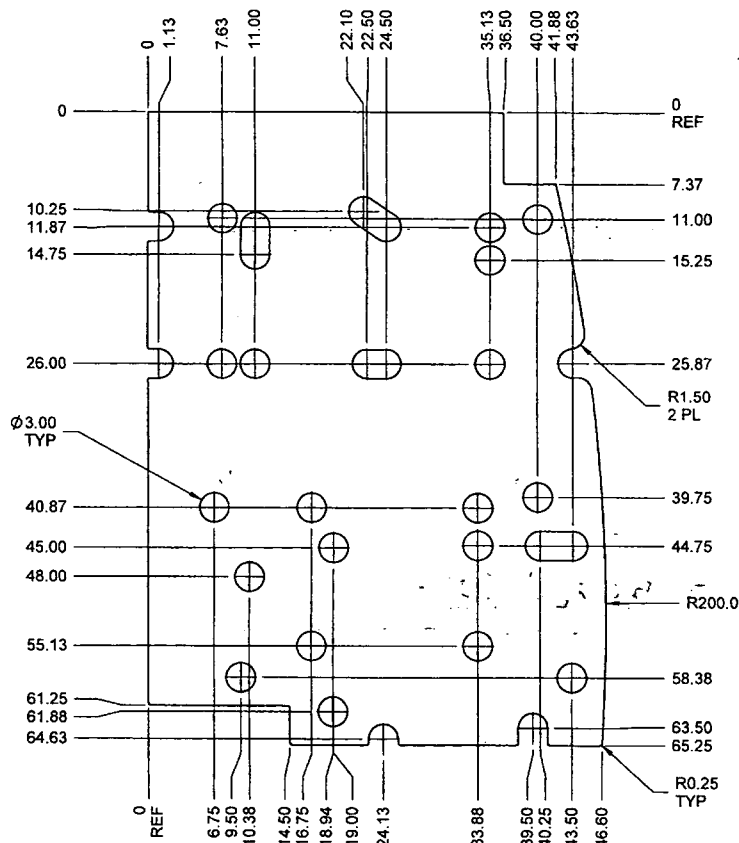
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 48210

PL 1104-5



D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.27 lbs
- 8) CHECK PER TEMPLATE DT8965

RELEASED
09/04/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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